Work Ord <i>May-27-13 8:4</i>		2106	Said		*10	2106*							Page 1
Item ID: Revision ID: Item Name:	D4030-041 Long Basket	Assembly (350)			Accept	*N900	<u> </u>	100)*	Setup	Start Stop	*N: *N	S1* S2*
Start Date: Required Date Reference:	5/27/13	Start Qty: 1.00 Req'd Qty: 1.00		*1* *1*		Cust Item Customer						14.	
Approvals:	Process Pl QC:	an:	Date:		Tooling: SPC (Y/N):		Date:	***************************************		Run	Start Stop		R1* R2*
Sequence ID/ Work Center I	 [D	Operation Description	•	* * 5.	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Re	vision Nbr											
D4030	С					•							
*100 *100* Packaging Packaging		Pick Kit Memo			0.00								13-06-0
110		Assemble as per dwg			0.00				,		7	LA	0 1 -
110 HandFinish Hand Finishing			label plate to		0.00 5 label, use scotchbrite	red pad to lightly	F			9	<u> </u>	PE 1	3-6-5.
¹20 *1 2∩*		QC5- Inspect part comp	-,-		0.00 S	3m (>			J				
OC					0.00	•							

Memo

120 QC

Quality Control

NCR:	Yes	/	No
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		•								DQA:	Date	::
NCR: Y	es / No				WORK ORDER	NON-CO	NFORM	MANCE / UP	PDATE			
										QA Closed:	Date	
Work Orde	.				DISPOSITIO	N			AGAINST DI	EPARTMENT	/PROCESS	
Work Orde	·· 				Rev	work		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	0.				1	icrap	ſ	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-	as-is	Therm	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	o				Work Order Up	date		Large Fab	Composite]	Supplier	
		r								1	<u> </u>	
Root				Desc	cription of work order u	•	Initial		ction	Sign &	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	00.1
Cause	Date	Step	Qty	_	or Non-conformance	Cr	ief Eng	Desc	cription	Date	Verification	QC Inspector
Ooc/Data	_											
quip/Tooling Operator	_											
Material	-											
etup												
Other	-											
rocess												
Supplier					1							·
raining		ĺ										
Jnapproved												
						FAUL	T CATE	GORY				
Landin	g Gear			_	General		1			_	Γ-	-
ļ	Bending			-	Bend	_	Grain		<u> </u>	Ovalized	. -	Pressure/Forced
ļ	Centre No	ot Concer	ntric to	o/s	BOM/Route	-	Hardwa		<u> </u>	Over/Under	—	Temperature/Cure
}	Cracks				Broken/Damaged	<u> </u>	4 '	on incomplete	,, , <u> </u>	Part Incorre	 	Weld
	Crushed/	Crimped		1	Burrs		4	ions Incomplete,	Unclear	Part Lost/M		Wrong Stock Pulled
ļ	Cuffs			-	Countarink	<u> </u>	Mainte Mislabe		-	Part Moved Positioned V		
-	Heat Trea		Tubo	}	Countersink Cut Too Short		Misread		-	Power Loss/		Other
-	Inspection Ripples in		rube	-	Drill Holes		Offset	1	L	Ti ower ross/	Juige [Joiner
1	Torque W		extrusio	,	Drawing		-1	Calibration				
Ì	Turning S			·	Finish	<u> </u>	1	Sequence				

Wave/Twist in Tube

May-27-13 8:41:05 AM Item ID: D4030-041 Accept *N900040100* Setup Start Revision ID: Long Basket Assembly (350) Item Name: Start Qty: 1.00 **Start Date:** 5/27/13 **Cust Item ID:** Req'd Qty: 1.00 Required Date: 6/05/13 **Customer:** Reference: Run Start **Tooling:** Process Plan: Approvals: Date: Date: Stop Date: _____ SPC (Y/N): QC: Date: Set Up/ Reject Sequence ID/ Operation Tool ID Tool # Plan Accept Reject Insp. Work Center ID Description Code Qty **Qty** Number Stamp **Run Hours** 130 Identify as per dwg & Stock Location: 0.00 *120* 0.00 PM 103/05 Packaging Memo Packaging OC21- Final Inspection - Work Order Release 0.00 140 MUS 13-06-06 MF 13-6-6 *1/10* OC 0.00 Memo Quality Control

											DQA:	Date	e:
NCR:	es/	/ No				WORK ORDER NON-C	10:	NFORM	MANCE / UPDATE				
											QA Closed:	Date	2:
Work Orde	or.				. "	DISPOSITION			AGA	AINST DE	PARTMENT	/PROCESS	
Part N	•					Rework Scrap Use-as-is			Machining Sma	stube II Fab shing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	VO.			·		Work Order Update			Large Fab Comp	~ ~]	Supplier	
Root					Descri	otion of work order update	ı	nitial	Action		Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling								;					
Operator													
Material							Ì						
Setup													
Other					75								
Process													
Supplier							l						
Training													
Unapproved											<u></u>		
					-	F <i>i</i>	AUL	T CATE	GORY				
Landi	ng (ear				General		4		r	7	_	_
		Bending				Bend	<u></u>	Grain		<u> </u>	Ovalized	_	Pressure/Forced
-		Centre No	ot Conce	ntric to	o/s	BOM/Route	匚	Hardwa	re	<u> </u>	Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	t L	Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/Unclear	<u></u>	Part Lost/Mi	ssing	Wrong Stock Pulled
,		Cuffs				Contamination		Mainte	nance		Part Moved		
		Heat Trea	ıt			Countersink		Mislabe	led		Positioned V	Vrong	_
		Inspection	n Strip in	Tube		Cut Too Short		Misread			Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

May-27-13 8:41:02 AM

Work Order ID:

102106

Parent Item:

D4030-041

Parent Item Name:

Long Basket Assembly (350)

Start Date: 5/27/13

Required Date: 6/05/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A new issue DD 10.03.23 verified by:EC

IPP Rev:B as per dwg revB DD IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC

10.04.20 verified by:EC IPP Rev D 12.03.27 per NCR12-1239 EC verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measur	Qty on e Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4086-200		Manufactured	No				Each	21.0000		1			
Placard, Max Load											15		
				Location		Loc Oty	1	Loc Code			,		
				ST093		21							
					0556	12							
					611	1							
				96	251 519 !	1 7			4	8519			
D2530		34 6 . 1	No	98	519	100	Each	0.0000		<u> ۱۲۱ مره</u>			
Handle Weldment		Manufactured	NU			. 100	Eacn	9.0000	1	1	-70	3	
Transic Werdinent													1 10 10 10 10 10 10 10 10 10 10 10 10 10
				Location		Loc Qty	Ī	Loc Code					
				ST205		1							
					086	ı							
				ST255	0263	8			10	0263			
D2535		Manufactured	No	10	0203	100	Each	22.0000	2	2	ť		
Spring		Manufactured	110			100	Lacii	22.0000	2	2	2B		
ор <u>s</u>				Location		Los Otro	,	Las Cada					
				<u>Location</u>		Loc Qty	1	Loc Code					
				ST011	248	22 22			61	248			
D2537		M C	No	90	240	100	Each	110.0000	2		_		
Bushing		Manufactured	110			100	Lacii	110.0000	2	2	73	13	3-06-0
Dasning				T		I O+-		C			0		
				Location		Loc Oty	Ī	Loc Code					
				ST008	011	24							
					011	24							
				ST011	0454	86							
					713	42 20			91	4117			
					426	24				11.7			

Page 1

NCR:	⁄es	/ No				WORK ORDER NON-	COI	NFOR	MANCE / UP	DATE	QA Closed:	Date	:
Work Orde	-					DISPOSITION Rework Scrap			Skid-tube Machining	AGAINST DE Crosstube Small Fab		/PROCESS Water Jet d. Eng. Coor.	Engineering Quality
NCR I						Use-as-is Work Order Update		Thern	noforming Large Fab	Finishing Composite	4	re/Packaging Supplier	Other
Root						ption of work order update		nitial	1	tion	Sign &	_	
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data						•							
Equip/Tooling	Ш											· 	
Operator	Ц												
Material	Ш												
Setup	Ш												
Other	Ш						1						
Process	Ш				i								
Supplier	Ш										1		
Training	Ш												
Unapproved									j				
		<u>:</u> :					AUL	T CATE	GORY			·	
Landi	ng G	iear			_	General					7	_	7
	Ш	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Ш	Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure
·		Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorred	-	Weld
		Crushed/	Crimped			Burrs		instruct	tions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance-		Part Moved		
		Heat Trea	at			Countersink		Mislabe	eled		Positioned V	/rong	_
•		Inspectio	n Strip in	Tube		Cut Too Short	L	Misread	d	L	Power Loss/	Surge	Other
		Ripples in	n Bend			Drill Holes		Offset				<u></u> .	
		Torque W	Vaves in E	Extrusio	n [Drawing		Out of	Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

May-27-13 8:41:02 AM

	102106 D4030-041					Start I	Date: 5/27/13		Required Date: 6/05/13
	Long Basket Assembly (350)						Qty: 1.00		Required Qty: 1.00
D3913-041 Long Basket Base Assemb	Manufactured	No		100	Each	1.0000	1	1	H 13-6-5
·			Location 102104	Loc Oty	,	Loc Code	·/		
		μ	100171	1					
D3914-041 Long Basket Lid Assembly	Manufactured	No	102111	100	Each	1.0000	1 /	; 1	Bl 13-6-5.
			Location	Loc Oty		Loc Code			
			GA 100179	1 1					
D3917-3	Manufactured	No		100	Each	112.0000	6	6	/ 1 8
Washer			•				C		
			Location	Loc Oty		Loc Code			•
			ST072	112					
			100397	82					,
			92514	1			-0.00	<u> </u>	
			97710	29		12.0000	971		
D3953-3	Manufactured	No		100	Each	43.0000	2	2	~ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \
Gas Spring Stud, Lid				_			Carrier Haller		
			Location	Loc Qty		Loc Code			
			· GA	1					•
			87592	1			-		•
			ST075	28					
			100485	28			Thod	46	
			ST076	14			1004	עיט	
D2052 #	_		88494	14		(2,000			
D3953-7	Manufactured	No		100	Each	63.0000	2	2	2n 13-04.
Spring Spacer							The second of	wer + th	1)
			Location	Loc Qty		Loc Code			
			ST076	63					•
			100414	26			<u> </u>	19	
			94669 99148	13 24			946	41	•
			99148	24					

											DQA:	Date:	
NCR: Y	Yes	/ No				WORK ORDER NON-O	COI	NFOR	MANCE / UP	DATE		<u> </u>	
											QA Closed:	Date:	
Work Orde	př.					DISPOSITION		ĺ		AGAINST DE	PARTMENT	/PROCESS	
Work Orac	-					Rework]		Skid-tube	Crosstube	ĺ	Water Jet	Engineering
Part N	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
NCR N	No.					Use-as-is Work Order Update	Thern	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other	
Root					Descri	ption of work order update		Initial	Act	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling	Ш						l						
Operator	Ш												
Material	Ш												
Setup	Ш												
Other	Ш		i										
Process	Ш		į										
Supplier	Ш				·								
Training													
Unapproved													
						F	AUI	LT CATE	GORY				
Landi	ng G	iear				General					_		
		Bending				Bend		Grain			Ovalized		Pressure/Forced
	П	Centre No	ot Concei	ntric to	o/s	BOM/Route	Г	Hardwa	ire		Over/Under	tolerance	Temperature/Cure

Inspection Incomplete

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Weld

Other

Wrong Stock Pulled

Broken/Damaged

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Burrs

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Cracks

Cuffs

Heat Treat

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

May-27-13 8:41:04 AM

Work Order ID: Parent Item:	102106 D4030-041					Start	Date: 5/27/13		Required Date: 6/05/13
Parent Item Name:	Long Basket Assembly (350)						Qty: 1.00		Required Qty: 1.00
03953-9 Gas Spring Washer	Manufa	octured No		100	Each	43.0000	2	2	- 75
			Location	Loc Oty		Loc Code			•
			ST076	43					,
			95127	43			95	7127	
3953-17 Gas Spring Spacer	Manufa	actured No		100	Each	22.0000	2	2	1.y5
			Location	Loc Oty		Loc Code			0
•			ST076	22					
			97100	2					
			97696	20			971	698	
3953-19 ias Spring Bracket	Manufa	actured No		100	Each	6.0000	1	1	~ ys
			Location	Loc Qty		Loc Code			•
			ST077	6					
			97691	6			91	1691	
3953-21 as Spring Bracket	Manufa	actured No	,	100	Each	36.0000	1	1	~ gb
			Location	Loc Qty		Loc Code			U
			ST075	8					
			97714	8			47	714	
			ST077	28				. ,	
			100404	28					
93969-3 pring (Basket Lid)	Manufa	actured No	•	100	Each	25.0000	1 <i> b</i>	0 (1	1 gB 13-06
			Location	Loc Qty		Loc Code			•
			ST262	23					
			91844	3					
			99623	20					
			ST272	2					
			97050	2					

		DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

										•	QA Close	d: Da	te:	
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMEN	T/PROCESS		****
Part N	•					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-	Water Jet od. Eng. Coor. ore/Packaging Supplier		Engineering Quality Other
Root		•			Descri	ption of work order update		nitial	A	ction	Sign &			
Cause		Date	Step	Qty	,	or Non-conformance	Ch	ief Eng	Des	cription	Date	Verificatio	n	QC Inspector
Doc/Data														
Equip/Tooling													-	
Operator													l	
Material											Ì			
Setup														
Other											1		1	
Process													ı	-
Supplier														
Training														
Unapproved			L							***				
						F	AUL	T CATE	GORY					
Landi	ng (Sear				General	_	•			_		_	
		Bending			_	Bend	L	Grain			Ovalized			Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route	L	Hardwa	re	L	Over/Und	er tolerance	Ш	Temperature/Cure
	\vdash	Cracks				Broken/Damaged	L	Inspecti	on Incomplete		Part Incorr	ect	\vdash	Weld
		Crushed/	Crimped			Burrs	L	Instruct	ions Incomplete,	/Unclear	Part Lost/I	∕lissing	\sqcup	Wrong Stock Pulled
		Cuffs			<u> -</u>	Contamination	L	Mainte	nance		Part Move	d		
		Heat Trea	ı t			Countersink		Mislabe	led	Ĺ	Positioned	_	_	
		Inspection	-	Tube	L	Cut Too Short		Misread	I		Power Los	s/Surge	Ш	Other
		Ripples in			<u>_</u>	Drill Holes		Offset						
		Torque W	aves in E	xtrusio	n L	Drawing	L	Out of (Calibration		-			
		Turning S	equence			Finish		Out of S	Sequence					
1		Wave/Tw	ist in Tub	oe .		Folio	1	Outside	Dimensions					

May-27-13 8:41:04 AM

Work Order ID: Parent Item: Parent Item Name:	102106 D4030-041 Long Basket Assem	bly (350)							Date: 5/27/13 Qty: 1.00		Required Date: 6/05/	
AN3-14A	Long Basket Assem		No			100	Each	141.0000	4	4	Required Qty. 1:00	
Bolt		Purchased	JNO			100	Lacii	141.0000		4	70	
				Location		Loc Qty		Loc Code			0	
				ST351	•	100						
					m125709	100						
				ST512		41						
					123759	41			123	759	•	
AN3-16A		Purchased	No			100	Each	74.0000	2	2	~	
Bolt		1 di ciidoca									20	
				Location		Loc Oty		Loc Code				
				GA		47						
					117441	47						
				ST352		27						
					122407	8						
					123900	19			123	900		
AN5-17A		Purchased	No			100	Each	246.0000	4	4		
Bolt									e ········		<i>}</i>	· · · · · · · · · · · · · · · · · · ·
				Location		Loc Qty		Loc Code			•	
				GA		36						
	,				117872	36						
				ST337		60						
					124215	50						
					124805	10			1242	45		
				ST514		150						
					125388	150					•	
AN4-12		Purchased	No			100	Each	91.0000	3	3		. 4 . 4
Bolt											<u></u>	13-06-0
				Location		Loc Oty		Loc Code			U	
				ST356		91						
				3.223	124805	41			124	805		
					m125709	50					•	

										DQA:	Date	e:	mann's
NCR: Y	es / No				WORK ORDER NON-	COI	NFORM	AANCE / UPD	ATE				
								· · · ·		QA Closed:	Date	e:	عوسود
Work Orde	, ÷.				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
WOIK OIGE	···				Rework	7		Skid-tube	Crosstube	1	Water Jet	Engineering	
Part N	lo				Scrap		ſ	Machining	Small Fab	ł	d. Eng. Coor.	Quality	
NCR N	lo				Use-as-is Work Order Update	_		oforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging _ Supplier _	Other	
Root				Descri	ption of work order update		Initial	Acti	on	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Ct	nief Eng	Descri	ption	Date	Verification	QC Inspect	or
Doc/Data													
Equip/Tooling			1										
Operator		1	}									:	
Material						1						İ	
Setup											E		
Other [
Process						1							
Supplier		Į		•								i	
Training						1							
Unapproved		1											
					F	AUI	LT CATE	SORY					
Landir	ng Gear				General		_			_			
	Bending				Bend	L	Grain			Ovalized	L	Pressure/Forced	t
	Centre N	ot Conce	ntric to (o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Co	ure
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld	
	Crushed/	Crimped			Burrs		Instruct	ions Incomplete/U	nclear	Part Lost/M	ssing	Wrong Stock Pu	illed
Ì	Cuffs				Contamination		Mainte	nance		Part Moved	_		
	Heat Tre	at			Countersink	Г	Mislabe	led		Positioned V	Vrong	<u>. </u>	
	Inspection	n Strip in	Tube		Cut Too Short		Misread			Power Loss/	Surge	Other	
	Inspection Strip in Tube Cut Too Short Ripples in Bend Drill Holes					Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

May-27-13 8:41:04 AM

Work Order ID:	102106								
Parent Item:	D4030-041					Start D	ate: 5/27/13		Required Date: 6/05/13
Parent Item Name:	Long Basket Assembly (350)					Start (Qty: 1.00		Required Qty: 1.00
AN310-4	Purchased	No		100	Each	130.0000	3	3	~ 2 <i>5</i>
NUT							-	~> /\ .4'.	J=
•		Ī	Location	Loc Qty		Loc Code			
		S	ST342	130					
			122800	2					
			124221	28			1248	121	
			M125716	50					
			M125752	50					
AN310C4	Purchased	No		100	Each	55.0000	2	2	
Nut									
		ī	Location	Loc Oty		Loc Code			0
		S	ST342	55					
			123831	2					
			124221	53			124	221	
MS21042L3	Purchased	No		100	Each	3,253.0000	6	 6	
Nut	i dichased					,		·· u	15 13-06-05
		<u>1</u>	<u>Location</u>	Loc Qty		Loc Code			y
		F	FP001	3					
			122141	3					
		(GA	18					
			122452	18					
		9	ST314	268					
		,	117885	32					
			119017	55					
			119075	138					
			123265	43		•			
		S	ST506	2964					
			123900	954					•
			124291	2010			124	1291	
				2010					

											DQA:	Date	e:
NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFORM	ANCE / UP	DATE			
											QA Closed:	Date	e:
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I	-					Rework Scrap	Skid-tube Crosstube Machining Small Fab			Pro	Water Jet d. Eng. Coor.	Engineering Quality	
NCR I	No.	:				Use-as-is Work Order Update		1	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root					Descri	ption of work order update		Initial	Act	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ct	nief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling	Ш												
Operator													
Material			1									i	
Setup													
Other													
Process													
Supplier													
Training													
Unapproved			İ										
						F	AUI	LT CATE	GORY				
Landi	ng G	ear				General		_			_		
		Bending				Bend		Grain			Ovalized		Pressure/Forced
	Ш	Centre Not Concentric to O/S BOM/Route Hardwa							re		Over/Under	tolerance	Temperature/Cure
	Cracks Broken/Damaged							Inspecti	on Incomplete		Part Incorre	ct _	Weld
	Crushed/Crimped Burrs											ssing	Wrong Stock Pulled
	Cuffs Contaminat							Mainte	nance		Part Moved		
		Heat Trea			Countersink	Mislabeled				Positioned V	Vrong		
		Inspection	n Strip in	Tube		Cut Too Short		Misread			Power Loss/	Surge	Other
	П	Ripples in	Bend			Drill Holes		Offset			=	· · · · · · · · · · · · · · · · · · ·	

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

May-27-13 8:41:05 AM

Work Order ID: Parent Item: Parent Item Name:	102106 D4030-041 Long Basket Assemb	ly (350)							pate: 5/27/13 Qty: 1.00		Required Date: (
MS21042L5 Nut		Purchased	No			100	Each	2,049.0000	4	4	715	
				Location	<u>n</u>	Loc Oty		Loc Code			,	
				ST314		1000						
					125654	1000			1256	54		
				ST506		49						
					123900	49						
				st507		1000						
					125535	1000						
MS24665-151		Purchased	No			100	Each	284.0000	3	3	<i>1</i>	
Cotter Pin					•				comes described to	~~~~~	<i>JP</i>	with the term of the second
				Locatio	<u>n</u>	Loc Qty		Loc Code			,	,
				GA		28						
					17566	28						
				ST323		256						
					122802	20			10115	200		
					124859	36			1242	857		
24024445 200			.		125646	200		100 0000			_	
MS24665-300 Cotter Pin		Purchased	No			100	Each	199.0000	<u> </u>	2		13-06-0
		i .		Locatio	<u>n</u>	Loc Oty		Loc Code			V	
				GA		37						
					118234	37						
				ST299		162						
					124555	162			124:	<u> </u>	•	

											DQA:	Dat	te: _	
NCR:	'es	/ No				WORK ORDER NON-	COI	VFOR	MANCE / UP	DATE	0.4.6(====1			,
-						·					QA Closed:	Dat	te:	
Nork Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part N	•					Rework . Scrap]		Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.		Engineering Quality
raiti	٠٠.	 	•	,		Use-as-is	1		noforming	Finishing	-1	re/Packaging	\dashv	Other
, NCR N	lo.					Work Order Update]	HIEH	Large Fab	Composite	1 100/3101	Supplier		
Root					Descri	iption of work order update	П	nitial	Act	ion	Sign &		Т	
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	n	QC Inspector
oc/Data														
quip/Tooling									•					
perator														
laterial														
etup														
ther														
rocess													1	
upplier									•					
raining							1							
napproved						<u> </u>								
						F	AUL	T CATE	GORY					
Landi	ng (Gear				General	_			<u></u>	-	-		
		Bending				Bend		Grain			Ovalized		-	ressure/Forced
		Centre No	ot Concer	ntric to	o/s	_BOM/Route		Hardwa	re		Over/Under	tolerance	_	emperature/Cure
		Cracks				Broken/Damaged		Inspect	on Incomplete		Part Incorred	ct	-	/eld
	Crushed/Crimped Burrs							Instruct	ions Incomplete/L	Inclear	Part Lost/Mi	ssing	\^	rong Stock Pulled
	Cuffs Contamination							Mainte	nance	<u></u>	Part Moved			
		Heat Trea	t		L	Countersink		Mislabe	led	<u> </u>	Positioned V	·		
	Inspection Strip in Tube Cut Too Short							Misread	I		Power Loss/	Surge		ther
		Ripples in	Bend		L	Drill Holes	Offset							
	Torque Waves in Extrusion Drawing							Out of Calibration						
	Turning Sequence Finish							Out of 9	Sequence					

Wave/Twist in Tube

May-27-13 8:41:05 AM

	102106					C. 4D	<i>5/27/12</i>			(105/12
	D4030-041						ate: 5/27/13		Required Dat	
Parent Item Name:	Long Basket Assembly (350)					Start (Qty: 1.00		Required Qt	y: 1.00
NAS1149F0432P Washer	Purchased	No		100	Each	1,360.0000	6	6	-yB	
		Loca	tion	Loc Qty		Loc Code			,	
		ST29	95	1360						
			122151	2						
			123522	4					•	
			123900	32						
			124580	22						
			124859	300			1248	13 1		
			125268	1000					_	
NAS1149F0563P Washer	Purchased	No		100	Each	688.0000	4	4	JB	
		Loca	tion	Loc Qty		Loc Code				
		ST29	95	688						
			121350	688			121	310		
NAS1149F0332P WASHER	Purchased	No		100	Each	12,498.000	8	8	- 25	
		Loca	<u>ition</u>	Loc Qty		Loc Code			O	
•		GA		182						
			122063	182						
		ST29		158						
			122063	158						
		ST29		3						
			123352	3						
		st510		7155						
		565.7	123900	7155						
		ST51		5000			1239	00		
		515.	125646	5000						
NAS1149C0432R	Purchased	No		100	Each	1,314.0000	2		· _	
Washer	i di chased					,			20	12-06-0
		Loca	ntion	Loc Qty		Loc Code				
						<u>Lot Cout</u>				
		ST29		1314						
			119124 122441	6 1308			122	441		
May-27-13 8:41.05	434			Packet Print						Page

NCR:	·													
<u> </u>									- -		QA Closed	: Date	:	
Work Orde	er:		. <u> </u>			DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part N	-					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet od. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root					Descri	ption of work order update		Initial Action			Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector	
Doc/Data	Ш						İ							
Equip/Tooling	Ш				1									
Operator	Ш										1			
Material	Ш													
Setup														
Other														
Process	Н													
Supplier	Н													
Training	Н		ļ								-			
Unapproved			<u> </u>	i				T CATE	CORV		1	<u> </u>		
Landi	na G	COR				General	AUL	.I CAIL	GORT					
Lanui	_	Bending				Bend		Grain		Г	Ovalized	Γ	Pressure/Forced	
		Centre No	nt Concei	ntric to (BOM/Route	-	Hardwa	are		Over/Under	tolerance –	Temperature/Cure	
		Cracks	or contect	11.10.10	"	Broken/Damaged	\vdash	4	ion Incomplete		Part Incorre	<u>-</u>	Weld	
	Cracks Crushed/Crimped					Burrs		4 '	tions Incomplete/U	Jnclear	Part Lost/M	<u> </u>	Wrong Stock Pulled	
	Cuffs					Contamination		Mainte	•		Part Moved			
	Heat Treat					Countersink	Mislabeled				Positioned \	Wrong		
						Cut Too Short		Misread	d d		Power Loss,	/Surge	Other	
						Drill Holes	Offset				-			
	├ ── │ `					Drawing	Out of Calibration			-				
	Turning Sequence					Finish	Out of Sequence							

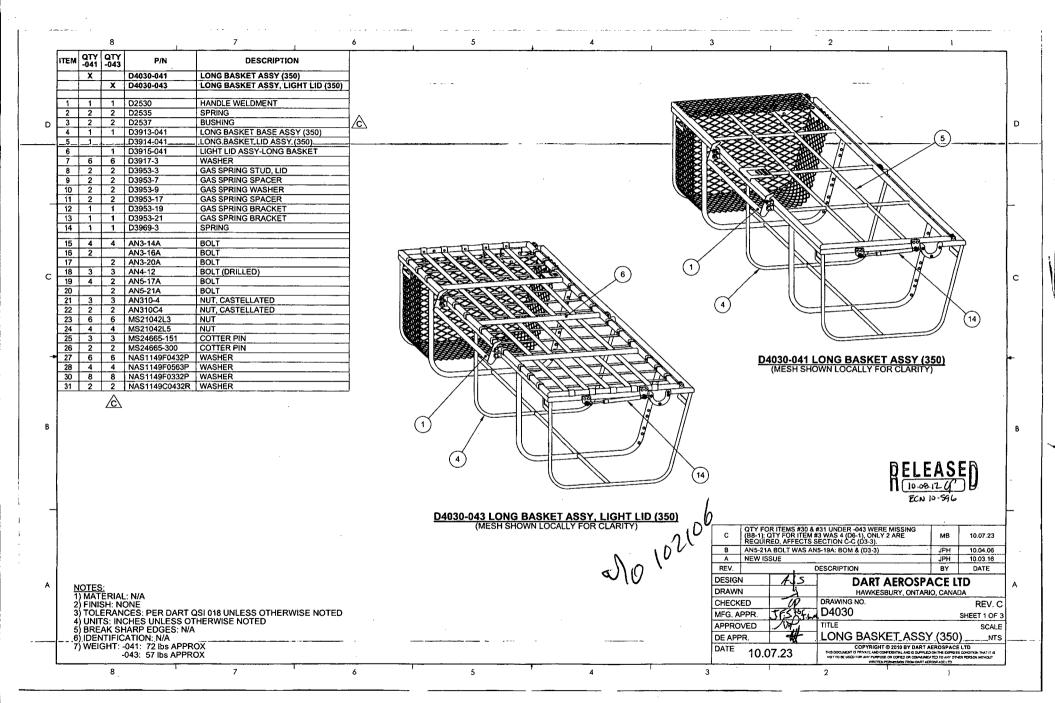
DQA:

Date:

Wave/Twist in Tube

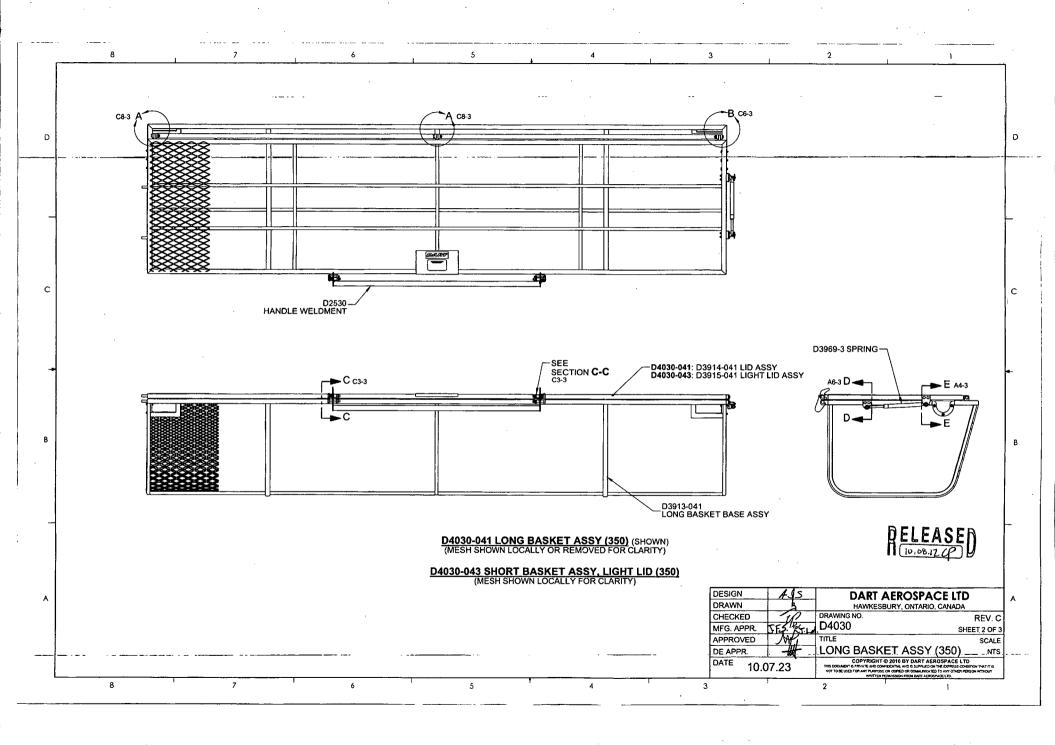
Finish Folio

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	DQA:DateDateDate.														
NCR: Y	Yes / No WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date:														
											QA Closed:	Da	te:		
Nork Orde	ŗ.					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS			
Part No	o					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	⊣	Water Jet d. Eng. Coor. re/Packaging Supplier		ngineering Quality Other	
	_					, voin opasis	J							<u></u>	
Root Cause		Date	Step	Qty	Descr	ription of work order update or Non-conformance	Initial Chief Eng		Action Description		Sign & Date	Verification	n	QC Inspector	
oc/Data quip/Tooling perator flaterial etup ther rocess upplier raining napproved															
			·			F	AUL	T CATE	GORY					· · · · · · · · · · · · · · · · · · ·	
Landin	g G	ear			_	General	_			_					
- - - - - - - - - - - - - - - - - - -	Bending Centre Not Concentric to O/S Cracks Broken/Damaged Burrs Cuffs Contamination Countersink Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing							Instruct Mainte Mislabe Misread Offset Out of (on Incomplete ions Incomplete/U nance led I	Inclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong	Ten We	ong Stock Pulled	
	Turning Sequence Finish Out of Sequence														

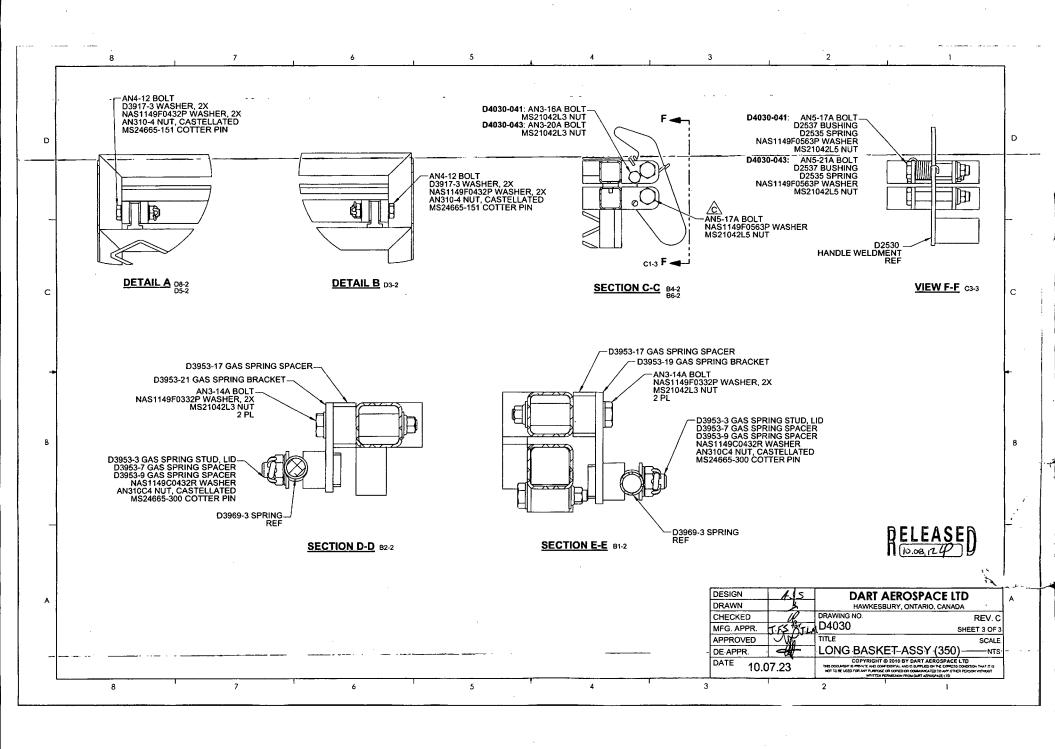
Wave/Twist in Tube



NCR: Y	es / No		•		WORK ORDER NON-C	CONFO	RMANCE / UP	DATE	QA Closed:	Date		
			· · · · · · · ·		1	T					·	
Work Orde	r:				DISPOSITION			AGAINST DI	EPARTMENT,	/PROCESS		
					Rework] [Skid-tube	Crosstube		Water Jet	Engineering	
Part N	0				Scrap] [Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
					Use-as-is	Th	ermoforming	Finishing	Rec/Sto	re/Packaging	Other	
NCR N	o				Work Order Update	J	Large Fab	Composite		Supplier		
Root				Descri	tion of work order update	Initia	Initial Action		Sign &			
Cause	Date	Step	Qty	(or Non-conformance	Chief E	ng Desc	cription	Date	Verification	QC Inspector	
oc/Data	ata											
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perator												
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Other]]									
rocess		ļ										
Supplier												
raining												
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Landin	g Gear				General			_	-	-	_	
	Bending				Bend	Grai	n		Ovalized	L	Pressure/Forced	
	Centre N	lot Conce	ntric to C	o/s	BOM/Route	Hard	ware	L	Over/Under	tolerance	Temperature/Cure	
	Cracks				Broken/Damaged	Insp	ection Incomplete		Part Incorred	it _	Weld	
	Crushed	/Crimped			Burrs	Instr	uctions Incomplete/	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs Contamination					Mai	ntenance		Part Moved			
Γ	Heat Treat Countersink					Misl	abeled		Positioned V	Vrong		
. [Inspection Strip in Tube Cut Too Short						Misread Power Loss/Surge Other					
	Ripples in Bend Drill Holes					Offset						
Ī	Torque Waves in Extrusion Drawing						Out of Calibration					
Turning Sequence Finish						Out of Sequence						
<u> </u>	Wave/Twist in Tube Folio						Outside Dimensions					

DQA:

Date:



										DQA:	Date:	
NCR: Y	es / No	ס			WORK ORDER NON-	COI	NFORM	/ANCE / UP	DATE			
	<u>-</u>								•	QA Closed:	Date:	
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	lo.				Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			-1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root		· /	T	Descri	ption of work order update	T	Initial	Ac	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance		nief Eng		cription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling								İ				
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Process												
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Unapproved					:		•					
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Landi	ng Gear				General		-		_	,		•
	Bendir	g		_	Bend		Grain			Ovalized	<u> </u>	Pressure/Forced
	Centre	Not Conce	entric to	o/s	BOM/Route		Hardwa	re	<u></u>	Over/Under		Temperature/Cure
	Cracks				Broken/Damaged	L	Inspecti	on Incomplete		Part Incorre	ct <u>·</u>	Weld
Crushed/Crimped Burrs					Burrs		Instruct	ions Incomplete/	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
Cuffs Contamination					Maintenance			Part Moved				
Heat Treat Countersink					Countersink	Mislabeled Positi			Positioned V	Vrong	•	
	Inspec		Cut Too Short	Misread				Power Loss/	Surge	Other		

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio